

Date: Wednesday, 3/8/2006 10:38:14 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHUT-OFF VALVE SHAFT	
Job Number :	26116			
Estimate Number :	12180			
P.O. Number :	N/A	Part Number :	D34705	
This Issue :	3/8/2006	Drawing Number :	D3470 REV.A	
Prsht Rev. :	NC	Project Number :	N/A	
First Issue :	N/A	Drawing Revision :	A	
Previous Run :	N/A	Material :	N/A	
Written By :	<i>SPR COMMENT BELOW</i>		Due Date :	3/31/2006
Checked & Approved By :	<i>06.03.08</i>		Qty:	40 Um: Each
Comment :	est rev A 06.02.06 new issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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**Comment:** Sub-Contracting OUTSIDE SERVICESIssue P/O: *00000768*

Email or Ship DXF file to vendor

Laser Cut per Dwg D3470 flat pattern D3470-5 F

Material release note required

2.0	D34703 F	ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total: *40* 24.0000 Each(s)
 ARM

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 26116

Part Number: D34705

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Abeloz 21 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Abeloz 21 (40)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/30 (40)

Job Completion



4 06/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

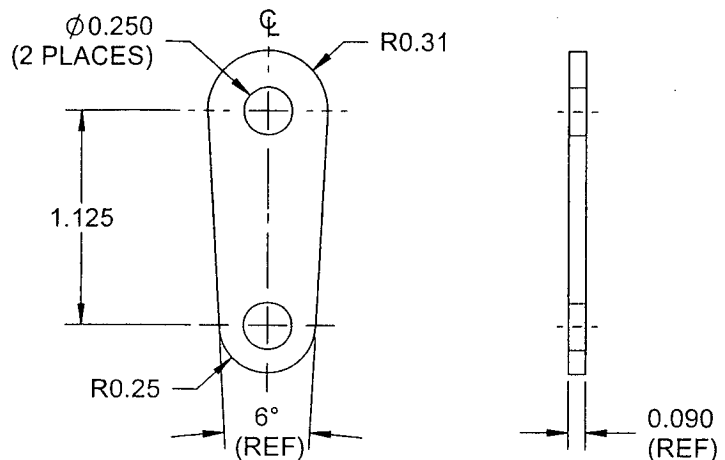
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN ✓	DRAWN BY ✓	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ✓	APPROVED ✓	DRAWING NO. D3470	REV. A SHEET 3 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

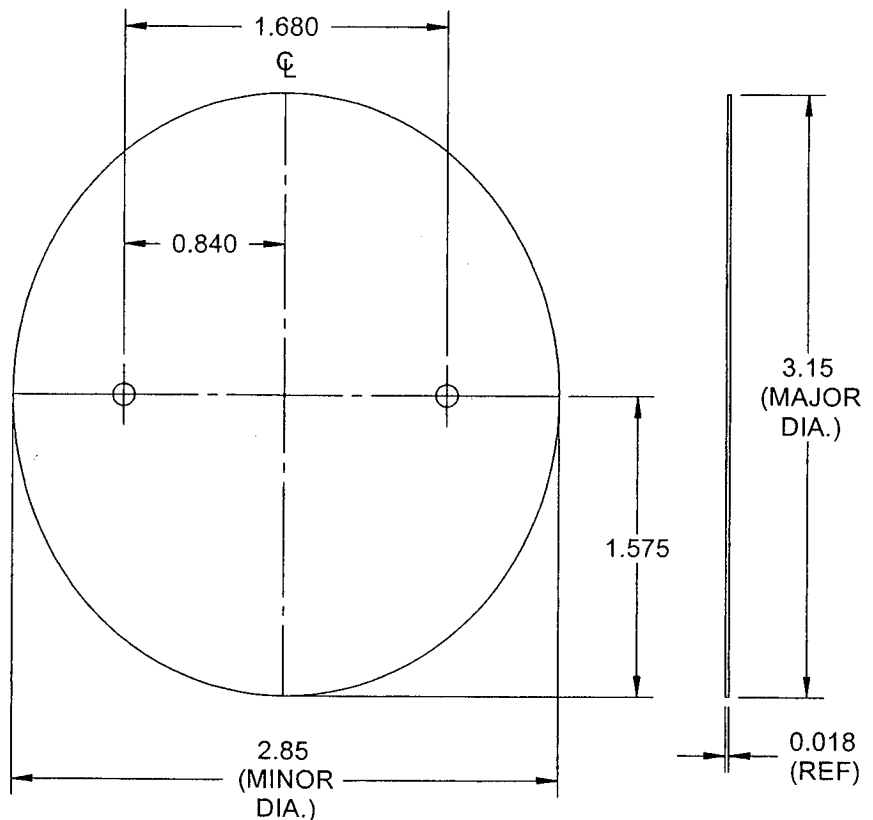
D3470-3 ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE.



D3470-5 PLATE VALVE

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH.




NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		AK Steel Corporation Metallurgical Test Report Confection Works Confection, OH 43612		Fig 1 Lead No. 710672 SRN No. 710672
INTRINSIC METALS PO BOX 340 MINNEAPOLIS, MN 55440		INTRINSIC METALS 306 R STEEVE ALBURN, WA 98001		MILITARY UNITS - PRODUCT - MILITARY UNITS PART NO. 710672 PART NO. 710672 BUYER'S ORDER NO. 42715-01
SKID ID PECE HEAT	SKID ID PECE HEAT	PART COIL ID NET WEIGHT	SKID ID PECE HEAT	SKID ID PECE HEAT
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INDUSTRIAL LASER P.O. - 110880 S.O. - 374786 FIRM 01 - 3 SHES

3/17/06

604-546-453. 2/11/2020

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8" PRM, AMS5513H X MRK&FTN, MIL5059D, AMD3, X CROWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C	Carbon-Pct	.059	CR	Chromium-Pct
CU	Copper-Pct	.342	MN	Manganese-Pct
MO	Molybdenum-Pct	.285	N	Nitrogen-Pct
NI	Nickel-Pct	8.150	P	Phosphorus-Pct
SI	Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GURLEPH, OMN K123
Control #: S0C60214
Part #: 74270441
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

